Work Orde November-15-12				*932	204*				·			Page	1
Item ID: Revision ID:	D2932-1			Accept	*NC	300	040	1በር)* s	etup Start	*N	S1*	
Item Name:	Saddle LH O	ut, 206			•					Stop	*N	S2*	
Start Date:	11/15/12	Start Qty: 6.00	*6*		Cus	t Item I	D:						
Required Date: Reference:	11/30/12	Req'd Qty: 6.00	*6*		Cus	tomer:	**						
Approvals:	Process Pl	an: MUゴ	Date: \2-\\-\	Tooling:		Da	ite:		R	tun Start	* N	R1*	
			Date:	1	2		ite:			Stop	*N	R2*	
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	To	ool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr	Re	vision Nbr		**************************************									
D2932	Re	v C	••										
*100 *100* HAAS I		HAAS CNC VERTICA	L MACHINING #1	0.00	70	13	101/0	9	6	_			
HAAS CNC vertica	il machine #!	Program pa number are inspect as	art number and batch number programmed correctly.2-loer dwg D2932 & attached d visually inspect as per	Machine Step No 1 of Fo	olio and visually								
110				0.00	•								
110		CONVENTIONAL MI	LLING MACHINE		0-	_	1.1.0		6	OB			•
Mill Conv		Memo		0.00	90-	13/	0/04			7			-
Conventional Millin	ng Machine	Machine K	eyway and inspect per atta	ched dimension sheet				,					
120		QC1- Inspect dimensio	ns to dimension sheet	0.00		Ä				, \ ~	*.		
120 QC Quality Control		Memo		0.00	50	310	1/09		6	<i>P</i>			-

NCR:	Yes	/ No				WORK ORDER NON-	CON	NFORN	AANCE / UPE	DATE	QA Closed:	Date	:
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS Water Jet	Engineering
Part N			-			Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	d. Eng. Coor. re/Packaging Supplier	Quality Other
TCK 1	•••					Total opacio	ا ا				J		
Root Cause		Date	Step	Qty		ption of work order update or Non-conformance	1	nitial iief Eng	Act `Descr		Sign & Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved												·	
							AUL	T CATE	GORY			· · · · · · · · · · · · · · · · · · ·	
. Landi		Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspectio Ripples in	Crimped at n Strip in n Bend	Tube		General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instruct Mainte Mislabe Misread Offset	on Incomplete ions Incomplete/Unance eled	Jnclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V	ct issing Wrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
1		Torque V	Vaves in 1	Extrusio	n	Drawing		Out of 0	Calibration				

Out of Sequence

Outside Dimensions

DQA:

Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Finish Folio

Work Orde				*933	204	*							Page 2
Revision ID:	D2932-1 Saddle LH Ou	t, 206		Accept	*N	900	040	100)*	Setup	Start Stop	171.	S1* S2*
	11/15/12	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*			ust Item I ustomer:	D:						
Approvals:		n:	Date:	Tooling: SPC (Y/N):			ite:			Run	Start Stop		R1* R2*
Sequence ID/ Work Center II 130 *130* QC. Quality Control)	Operation Description QC8- Inspect parts - sec	ond check	Set Up/ Run Hours 0.00		13/01	Tool#	Plan Code	Accept Qty	t Re Qt		Reject Number	Insp. Stamp OS OS
140 *110* HandFinish Hand Finishing		Chemical Conversion C Memo	oat per QSI005 4.1	0.00					6	ф	<u> </u>	K 13-	1-10.

150

150 Powdercoat

Powder Coating

0.00

6 d pl 12 1-74.

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-O	100	NFORM	MANCE / UP	DATE			
											QA Closed:	Date:	
Work Orde	or.	3 8 1 1				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	***
WOIR Old	- · ·					Rework	1		Skid-tube	Crosstube]	Water Jet	Engineering
Part f	No.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	_					Use-as-is			noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR I	۷o					Work Order Update]		Large Fab	Composite]	Supplier	
Root					Descri	tion of work order update		nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling											,	ļ	·
Operator	Ш												
Material													
Setup ,	Ш												
Other	Ш												
Process	Ш												
Supplier	Ш								,				
Training	Ш												
Unapproved													
						F	AUL	T CATE	GORY				
Landi	ng G	iear				General	_	,			7		-
	Ш	Bending				Bend		Grain			Ovalized		Pressure/Forced
		Centre No	ot Concer	ntric to (o/s	BOM/Route	_	Hardwa	re	_	Over/Under	tolerance	Temperature/Cure
	Ш	Cracks				Broken/Damaged	L	Inspecti	on Incomplete		Part Incorre	ct	Weld
	Ш	Crushed/0	Crimped,			Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Ш	Cuffs				Contamination		Mainte	enance		Part Moved		
		Heat Trea	t			Countersink		Mislabe	eled		Positioned '	Wrong	-
		Inspection (Strip in	Tube		Cut Too Short		Misread	d		Power Loss,	/Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

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Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

Work Orde				*932	PN4*				Page 3
Revision ID:	D2932-1 Saddle LH Out	i, 206		Accept	*N900040	100*	Setup	Start Stop	*NS1* *NS2*
Start Date: Required Date: Reference:	11/15/12 11/30/12	Start Qty: 6.00 Req'd Qty: 6.00	*6' *6'		Cust Item ID: Customer:				
Approvals:	Process Pla	n:	Date:		Date:		Run	Start Stop	*NR1* *NR2*
Sequence ID/ Work Center II 160 *160* QC Quality Control)	Operation Description QC3- Inspect Part Finish Memo	1	Set Up/ Run Hours 0.00	Tool ID Tool #	Plan Acce Code Qty	ept Re Qt	y :	Reject Insp. Number Stamp
170 Packaging Packaging		Identify as per dwg & St Memo	ock Location:	0.00		(, OX _		13-01-15
180 *180* QC Quality Control		QC21- Final Inspection Memo	- Work Order Releas	e 0.00 0.00				13/1	1/17 8

N (3-01-15

											DQA:	Date:	
NCR:	Yes /	No				WORK ORDER NON-C	10	NFORM	ANCE / UPDA	\TE	·		-
											QA Closed:	Date:	
Work Orde	or:					DISPOSITION				AGAINST DEI	PARTMENT	/PROCESS	
work Orac	er					Rework			Skid-tube	Crosstube		Water Jet	Engineering
Part f	No.					Scrap)	Small Fab	Pro	d. Eng. Coor.	Quality
l						Use-as-is		l	noforming	Finishing		re/Packaging	Other
NCR I	No					Work Order Update			Large Fab (Composite 🗌		Supplier	
					<u></u>								1
Root						ption of work order update		nitial	Action		Sign &		
Cause	, [Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Descript	tion	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator	Щ												
Material	Ш												
Setup	Ш		•		,			•					
Other	Н												
Process	Ш						İ						
Supplier	Ш		-										
Training	Н												
Unapproved				<u> </u>									
							AUL	T CATE	GORY				
Landi	ing Gea					General	_	1		 	1		7
		nding				Bend	_	Grain			Ovalized	_	Pressure/Forced
	$\boldsymbol{\vdash}$		t Concer	ntric to	o/s	BOM/Route	╙	Hardwa			Over/Under	<u> </u>	Temperature/Cure
	\vdash	icks			_	Broken/Damaged	_	1	on Incomplete		Part Incorre	<u> </u>	Weld
	\vdash		rimped.		_	Burrs		4	ions Incomplete/Und		Part Lost/M	issing	Wrong Stock Pulled
!	L Cu					Contamination		Mainte		}	Part Moved		
	He	at Trea	t			Countersink		Mislabe	led	<u> </u>	Positioned V		7
	line	nection	Strin in	Tube		Cut Too Short	1	Misread	İ	1	Power Loss	Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

Work Order ID:

93204

Parent Item:

D2932-1

Parent Item Name:

Saddle LH Out, 206

Start Date: 11/15/12

Required Date: 11/30/12

Page 1

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP: B00.06.26New DWG rev, (mpp 2069)EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure		Qty per Kit.	Total Qty	Qty Issued	Date Issued	Status
D6101-003 Saddle Billet, 7075		Manufactured	No			100	Each	20.0000	1	6			
				Location		Loc Qty	Lo	oc Code					
				MAT040		19							
				73775	;	2			*10				
				73780)	7							
				78599)	10							
				80765	;	0							
				MAT044		1							
				73769)	1							
				912	38				4		KK 1	3/01/	06

										DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON-C	ON	IFORM	/IANCE / UPI	DATE			
										QA Closed:	Date:	
Work Orde	er:				DISPOSITION	١			AGAINST DE	PARTMENT	/PROCESS	
Part N	lo				Rework Scrap Use-as-is Work Order Update		f Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root		T		Doscri	ption of work order update		nitial	Λct	tion	Sign &		T .
Cause	Date	Step	Qty	ł	or Non-conformance	j	ief Eng		ription	Date	Verification	QC Inspector
Doc/Data	Date	Jiep	Qty		or Non comormance	Cin	ici Liig	0030	ription	Dute	Vermeation	QC IIISPECTOI
Equip/Tooling												
Operator					•							
Material												
Setup	_											
Other												
Process												
Supplier -		1 -										
Training												
Jnapproved												
					F	AUL	T CATE	GORY				
Landir	ng Gear				General					_		
	Bending				Bend	Ш	Grain			Ovalized		Pressure/Forced
	Centre N	ot Conce	ntric to	o/s	BOM/Route	Ш	Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged		Inspecti	on Incomplete	L	Part Incorre	ct	Weld
	Crushed/	'Crimped			Burrs	Ш	Instruct	ions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	-	Mainte			Part Moved		
	Heat Trea	at			Countersink	Ш	Mislabe	led		Positioned V		"
	Inspectio	n Strip in	Tube		Cut Too Short		Misread	1		Power Loss/	Surge	Other
	Ripples in	n Bend			Drill Holes	\square	Offset					
	Torque V	Vaves in E	Extrusio	n 🗍	Drawing		Out of 0	Calibration				

Out of Sequence

Outside Dimensions

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Turning Sequence

Wave/Twist in Tube

Finish .

Folio

DART AEROSPACE LTD	Work Order:	93204
Description: 206 Saddle, Outboard, Left side	Part Number:	D2932-1
Inspection Dwg: D2932 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Re	corded Act	ual Dimens	ions		
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
Α	0.100	0.140		104	:110	.109	,106		
_B	0.100	0.140		,107	.116	114	108		
С	0.100	0.140		. 115	.117	.114	. 115		
D	0.210	0.230		120	.770	. 120	- 120		
Ē	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.290		-
G	2.495	2.505		2500	2.500	2.500	2.500		
Н	0.510	0.515		-514	.514	.54	-514		·
- 1	1.572	1.582		1.577	1.577	1.577	1577		
J	2.495	2.505		2,500	2.500	2.500	7.50		
K	0.257	0.262		.258	• 158	258	.258		
L	0.312	0.317		.314	-314	314	1430		
М	0.235	0.240	-	720	238	.738	. 238	-	
N	0.100	0.140		120	100	120	122		
0	0.540	0.560		. 549	, 550	.549	. 120		
Р	0.490	0.510		444	.497	501	,497		
Q	3.715	3.725		3.720	3,720	3 720	3.770		
R	2.470	2.510		2.488	2.488	2.489			
S	0.240	0.270		:753	. 249	2010	<u> </u>		
Ť	0.100	0.180			.140		248		
Ü	1.625	1.635	·	1740		1.630	140	ļ	
V	1.362	1.372		1,650	1.630		1,630		
w	0.316	0.321	-	1,367	1,367	1.367	1,367	ļ	
X	1.125	1.145		316	316	316	3/6		
Ŷ	1.565	1.585		1.133	1.135	1.136	1,136		
Z	0.178	0.198		1.573	1.573	1.575	1.575		
AA	0.170	0.130		188	158	. 188	.188		
AB			_	<u> </u>					
AC AC									
AD	-								
AE									
AF									
AG AH									
117		ept/Rejec			-				

			$\neg A \circ$
Measured by: YO	Audited by	HA	70
Date: 13/01/09	Date:	12 101100	<u>Ó8</u>
	Date.	13/01/09	7-89

Rev	Date	Change	Revised by	Approved
Α		New Issue	RF	
В	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	1
С		Revised per drawing revision C	KJ/JLM X	Gill

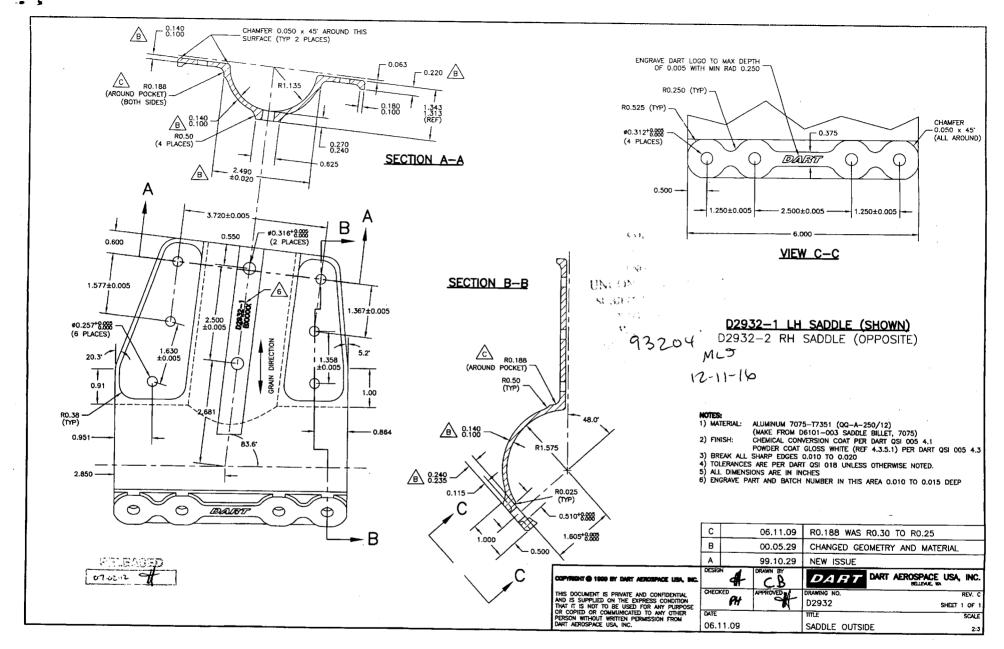
DART AEROSPACE LTD	Work Order:	93204
Description: 206 Saddle, Outboard, Left side	Part Number:	D2932-1
Inspection Dwg: D2932 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
Α	0.100	0.140		.106	117			1	
В	0.100	0.140		. 111	117				
С	0.100	0.140		.116	122				
D	0.210	0.230		1219	219			1 - 1	
E	1.245	1.255		1250	et19 1.2	50			
F	1.245	1.255		1.250	1 255				
G	2.495	2.505		2,500	2.500				
Н	0.510	0.515		-514	.514				
1	1.572	1.582		1.577	1,577				
J	2.495	2.505		1.500	1500				
K	0.257	0.262		. 158	258			++	
L	0.312	0.317		- 314	20				
М	0.235	0.240		- 738	724			+	
N	0.100	0.140		-119	.119			+	
0	0.540	0.560		549	-548			1	
Р	0.490	0.510		.495	500		·	++	
Q	3.715	3.725		3.00	3.120	-		+	
R	2.470	2,510		3,720 2,488	2,488				
S	0.240	0.270		1247	- 247				
T	0.100	0.180		140	140				
Ū	1.625	1.635		1.630	1.630				
V .	1.362	1.372		367	1367		<u> </u>	+	·
W	0.316	0.321	-	316	211			-	
X	1.125	1.145	-	1,136	1 12 5			-	
Y	1.565	1.585		1.575	.316 1,135 1,574				
Z	0.178	0.198		· 138	-138			-	
AA	3.170			* (20	* (<i>08</i>	-		 	
AB					 				
AC	-								
AD				4					
AE				<u>.</u>			·		
AF									
AG								1	
AH									
	٨٥٥	ept/Rejec							

			.	\wedge \sim
Measured by: YO	Audited by	13/01/09	HA	UB
Date:	Date:		13/01/09	- 8-83
	<u> </u>			

Rev	Date	Change	Revised by	Approved
Α		New Issue	RF	
В	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	1
С		Revised per drawing revision C	KJ/JLM X	GII!



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